

Work Order ID 150904***150904***

Page 1

Monday, September 12, 2016 10:26:03 AM

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Collective Lock AS350
Start Date: 9/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/12/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **SEP 12 2016** Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3372	Rev B								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.05							
Small Fab	Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372 Identify as D3372-3								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Small Fab								
Small Fab	Memo	0.02							
Small Fab	1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5								

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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130

0.00

130

Small Fab

Small Fab

Memo

0.02

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty	Part Number	Description	Batch
A/R	N/A	Locktite 262	M133046

Identify as D3372-053

2-Assemble D3372-051 as per Dwg

1	FF	OCT 17 2016
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140

0.00

140

Large Fab

Large Fab

Memo

0.01

Tack weld lock shaft as per Dwg D3372

A/R	SS Rod	Batch
		M134447

1	12/16/10/17
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Work Order ID 150904

Monday, September 12, 2016 10:26:03 AM

150904

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Item ID: D3372-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Collective Lock AS350

Start Date: 9/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/12/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location *** 499**

0.00

170

Packaging

Memo

0.00

Packaging

DAS
6
9-89

OCT 17 2016

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.02

DAS
21
9-89

OCT 18 2016

Quality Control

DAS
21
9-89

OCT 17 2016

DQA: _____ Date: _____



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OTHER : _____																									

Picklist Print

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Work Order ID: 150904

150904

Parent Item: D3372-041

D3372-041

Parent Item Name: Collective Lock AS350

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
IPP Rev:B Added Key ID _____ 06.03.21 EC
added D3384-043 DD 10.05.13 verified :EC IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3369-5 *D3369-5* Spacer		Manufactured	No				Each	2.0000		1			
									**			SEP 30 2016	DAS 6 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST032			2					
					139874			2					
5/16WC *5/16WC* Washer		Purchased	No			100	Each	641.0000	2	2			
									**			SEP 30 2016	DAS 6 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST583			641					
					m135440			641					
AN5-42A *AN5-42A* Bolt		Purchased	No			100	Each	12.0000	1	1			
									**			SEP 30 2016	DAS 6 9-8:
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST336			12					
					m132930			12					
D2728-7 *D2728-7* Dart Logo Label		Manufactured	Yes			100	Each	0.0000	1	1			
									**			OCT 17 2016	

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Parent Item: D3372-041

D3372-041

Parent Item Name: Collective Lock AS350

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

D3372-1
D3372-1

Main Body

Manufactured No

100 Each 6.0000 1 1

SEP 30 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST499

6

148599

6

D3372-5
D3372-5

Cam Lock Shaft

Manufactured No

100 Each 8.0000 1 1

SEP 30 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST032

8

123362

8

D3372-7
D3372-7

Slider Body

Manufactured No

100 Each 5.0000 1 1

SEP 30 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST499

5

141172

5

D3373-1
D3373-1

Cam Lock

Manufactured No

100 Each 22.0000 1 1

OCT 17 2016

Location

Loc Qty

Loc Code

GA

17

139798

3

147075

14

ST032

5

74862

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER :																									

Picklist Print

Monday, September 12, 2016 10:26:06 AM

Page 3

Work Order ID: 150904

150904

Parent Item: D3372-041

D3372-041

Parent Item Name: Collective Lock AS350

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

D3384-043

Manufactured No

100

Each

3.0000

1

1

D3384-043

Cyclic Sock Assembly

OCT 17 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST500

3

141173

1

148600

2

HX-81

Purchased

No

100

Each

32.0000

1

1

HX-81

1/4"-20 SHCS 3/8" long

OCT 17 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST563

32

123436

32

NAS1149F0463P

Purchased

No

100

Each

710.0000

2

2

NAS1149F0463P

Washer

OCT 17 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST262

710

m127832

710

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							